

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001013**Date Inspected:** 10-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	
Electrode to specification:	Yes	No	N/A	
Qualified Welders:	Yes	No	N/A	
Approved Drawings:	Yes	No	N/A	
		Rod Oven in Use:	Yes	No
		Weld Procedures Followed:	Yes	No
		Verified Joint Fit-up:	Yes	No
		Approved WPS:	Yes	No
		Delayed / Cancelled:	Yes	No
Bridge No:	34-0006	Component:	CalTrans mock up	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Dan Hernandez was present to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

114m lower shaft assembly

Caltrans QA Inspector observed ZPMC personnel perform Carbon Air Arc gouging a groove in the weld run off tabs for corner connection weld of skin plate D to skin plate E to allow proper welding of the weld joint. ZPMC personnel were also observed grinding interior connection plate muc-a58 at locations where weld run off tabs were removed by torch cutting.



WELDING INSPECTION REPORT

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Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan
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Quality Assurance Inspector

Reviewed By:	Cuellar,Robert
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QA Reviewer
